



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3492-3

Job Sheet 202021



114
100 pcs
mf

Part No: D3492-3

Job Qty: 40 pcs

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/19

Job Tracking No:

Due Date: 11/21/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Hardinge - 1	40 pcs		11/21/19	0.00	1.50	Hardinge - 1		
120	QC 8	40 pcs		11/21/19	0.00	0.00	QC 8 - 12		mf 19/12/18
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Handfinish - 1-1 Chemical-B4B	40 pcs		11/21/19	0.00	0.14	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 -		



Container No: S241563



Part: D3492-3

Job No: 202021

Serial No/Batch: S241563

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/10/18

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					B4B	
					Handfinish - 1 - 3 - B4B	DEC 20 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140	Powdercoat - 1 White GI(A)-B4B	40 pcs	11/21/19	0.00 0.08	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	18/12/23
					Powdercoat - 4 - B4B	
150	QC 3	40 pcs	11/21/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	18/12/23
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	

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160	Packaging 3-1 - Stock - B4B	40 pcs	11/21/19	0.00	0.00	QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	BCE 19.12.23
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	

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				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	40 pcs	11/21/19	0.00 0.00	QC 21 - SA - 21	215
				QC 21 - SA - 70	21
				QC 21 - SA - 53	500 DEC 23 2019

Part Op 100 - (Hardinge) 1-Turn as per Folio FA632 & Dwg D3492
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) (Flat End Only)
 150 - (QC3- Inspect Part Finish)
 160 - (Identify as per dwg & Stock Location: FP001) LOCATION : FP001
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.750	6061-T6 Round Bar .750"	2.3600 ft (.059 ea)	100-Hardinge - 1	5226376

(049)

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6R0.750	2	13	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.750inches ± 0.010	0.760 0.740	.743	
2	Plug	0.582inches + 0.000 - 0.002	0.582 0.580	.582	
3	Plug	0.045inches + 0.000 - 0.002	0.045 0.043	.044	
4	Plug	0.060inches ± 0.005	0.065 0.055	.06	
5	Plug	0.060inches ± 0.005	0.065 0.055	.0605	
6	Plug	0.500inches ± 0.010	0.510 0.490	.501	
7	Plug	0.090inches + 0.000 - 0.002	0.090 0.088	.09	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	MRB (QSI042)			
Date : _____	Sequence #: _____	QTY Affected : _____				
Description Work Order Deviation		Disposition				
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table style="width:100%;"> <tr> <td style="width:33%;"> Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ </td> <td style="width:33%;"> Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ </td> <td style="width:33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ </td> </tr> </table> Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐
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Completed By		Lead hand / Supervisor				
QC / QA Coordinator		QC / QA Coordinator				